

# Work Order ID 44609

June 26, 2009 10:51:33 AM



Page 1

Item ID: D3467-15

Accept



Setup Start



Revision ID: C

Item Name: Deflector

Stop



Start Date: 15/07/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 09-09-24 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3467

Rev C

100

0.00



Shear

Memo

0.00

Shear

1- Cut Flat pattern 1.25" X 5.96" as per Dwg D3467

110

0.00



Small Fab

Memo

0.00

Small Fab

1-Deburr

120

0.00



Brake NC

Memo

0.00

Brake NC

1- Form as per Dwg D3467



*EB 09/01/09*

*EB 09/01/09*

# Work Order ID 44609

June 26, 2009 10:51:33 AM



Page 2

Item ID: D3467-15

Revision ID: C

Item Name: Deflector

Start Date: 15/07/2009 Start Qty: 4.00

Required Date: 03/08/2009 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 59

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



8/6/09

af

10/03/09 (4)

10/03/11  
mf  
10-3-10

June 26, 2009 10:51:32 AM

Page 1

**Parent Item:** D3467-15RevC

**Parent Item Name:** Deflector

**Comments:** Rev:C rev.C as per dwg

**Start Date:** 15/07/2009

**Required Date:** 03/08/2009

**Start Qty: 4.00**

**Required Qty: 4.00**

**Replacement  
Item ID**

**Mfg/  
Purch**

| Bin | Item |
|-----|------|
| 1   | 1    |
| 2   | 2    |
| 3   | 3    |
| 4   | 4    |
| 5   | 5    |
| 6   | 6    |
| 7   | 7    |
| 8   | 8    |
| 9   | 9    |
| 10  | 10   |
| 11  | 11   |
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| 93  | 93   |
| 94  | 94   |
| 95  | 95   |
| 96  | 96   |
| 97  | 97   |
| 98  | 98   |
| 99  | 99   |
| 100 | 100  |

### Primary Location

**Last  
Location**Route  
Seq ID

Unit of Measure

**Qty on  
Hand****Remaining  
Qty To Pick**

**Qty  
Issued**

**Date  
Issued**

## Status

M304S26GA

Purchased

No

100

sf

0.0000

0.2400

304/316 0.018 SHEET

Date: Monday, 12/01/2009 2:34:03 PM  
 User: Julie Dawson

## Process Sheet

|   |  |
|---|--|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services                                   | <b>Drawing Name</b> : DEFLECTOR                            |
| <b>Job Number</b> : 44609   |  |
| <b>Estimate Number</b> : 12179  |  |
| <b>P.O. Number</b> :  | <b>Part Number</b> : D346715                               |
| <b>This Issue</b> : 12/01/2009 <b>S.O. No.</b> :  | <b>Drawing Number</b> : D3467 REV B                        |
| <b>Prsht Rev.</b> : NC  | <b>Project Number</b> : N/A                                |
| <b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB                                   | <b>Drawing Revision</b> : B                                |
| <b>Previous Run</b> : 35216   | <b>Material</b> :  |
| <b>Written By</b> :   | <b>Due Date</b> : 30/01/2009 <b>Qty:</b> 4 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <u>JLD 09.01.12</u>                                  |  |
| <b>Comment</b> : Est Rev:A New Issue 06-04.20 EC<br>Est Rev:B As per Rev B 06-05-24 JLM |  |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|       |           |                     |
|-------|-----------|---------------------|
| 1.0 ✓ | M304S26GA | 304/316 0.018 SHEET |
|-------|-----------|---------------------|



**Comment:** Qty.: 0.0683 sf(s)/Unit Total : 0.2730 sf(s)

Pick:

304/316 0.018 SHEET

(M304S26GA)

Bach

1109398

|       |       |       |
|-------|-------|-------|
| 2.0 ✓ | SHEAR | SHEAR |
|-------|-------|-------|

**Comment:** SHEAR

Cut Flat pattern 1.25" X 5.96" as per Dwg D3467

|       |             |                               |
|-------|-------------|-------------------------------|
| 3.0 ✓ | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-------|-------------|-------------------------------|

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

|       |          |          |
|-------|----------|----------|
| 4.0 ✓ | BRAKE NC | NC BRAKE |
|-------|----------|----------|

**Comment:** NC BRAKE

Form as per Dwg D3467

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D3467-15 PAR #: \_\_\_\_\_ Fault Category: Small Pwb NCR: ☒ Yes No DQA: 10/03/16 Date: 10/03/16  
 Resolution: Accepted Disposition: use as is QA: N/C Closed: 10/03/16 Date: 10/03/16

| NCR: <u>44609</u> |      | WORK ORDER NON-CONFORMANCE (NCR)  |                             |  |                               |                               |                                    |                          |
|-------------------|------|---|-----------------------------|--|-------------------------------|-------------------------------|------------------------------------|--------------------------|
| DATE              | STEP | Description of NC<br>Section A  | Corrective Action Section B |  |                               | Verification<br>Section C     | Approval<br>Chief Eng              | Approval<br>QC Inspector |
|                   |      |   | Initial<br>Chief Eng        | Action Description<br>Chief Eng          | Sign &<br>Date                |                               |                                    |                          |
| 10.03.04          | 120  | DIMENSION 4.12 IS 4.08<br>ON 3 OUT OF 4<br>PARTS. Set-up error.<br>RC: LQA- | <u>10.03.04</u>             | ACCEPTABLE DEVIATION<br>THIS BATCH ONLY. | <u>SJS</u><br><u>10/03/16</u> | <u>SJS</u><br><u>10/03/16</u> | <u>10.03.04</u><br><u>05/10/16</u> | <u>10/03/16</u>          |
|                   |      |   |                             |  |                               |                               |                                    |                          |
|                   |      |   |                             |  |                               |                               |                                    |                          |

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:34:03 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DEFLECTOR

Job Number: 44609

Part Number: D346715

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/10/03/05

(44)

6.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

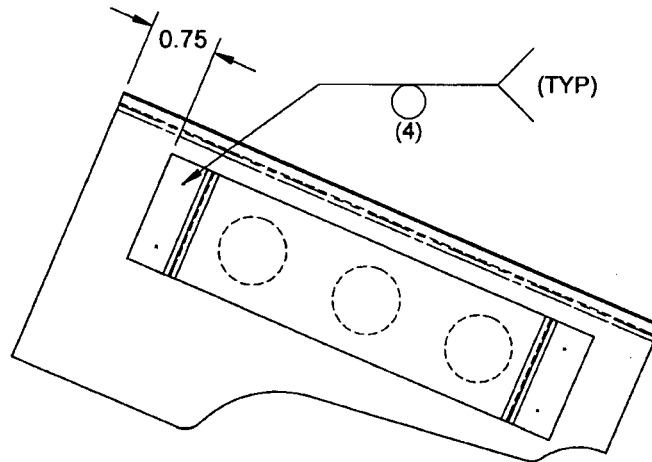
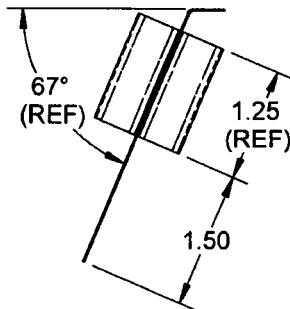
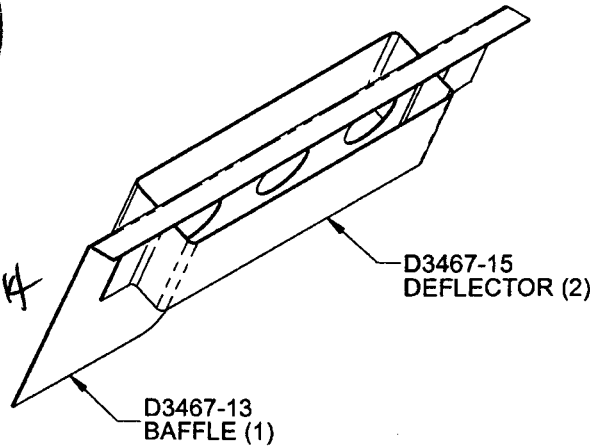
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**DART**

|                         |                       |  |                         |
|-------------------------|-----------------------|--|-------------------------|
| DESIGN<br><i>13</i>     | DRAWN BY<br><i>13</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                         |
| CHECKED<br><i>#</i>     | APPROVED<br><i>#</i>  | DRAWING NO.<br><b>D3467</b>                              | REV. B<br>SHEET 5 OF 15 |
| DATE<br><b>06.05.15</b> |                       | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:2            |

**RELEASED**  
*06.05.15***UNDER REVIEW***02.04.15*  
*Dim + Manufacturing*  
*Changes**06.01.14***D3467-049 BAFFLE & DEFLECTOR ASSEMBLY**

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WITHOUT NOTICE  
WORK ORDER  
NO. *44609*

**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY<br>-049 | P/N              | DESCRIPTION                            |
|-------------|------------------|--|
|             | <b>D3467-049</b> | <b>BAFFLE &amp; DEFLECTOR ASSEMBLY</b> |
| 1           | D3467-13         | BAFFLE                                 |
| 2           | D3467-15         | DEFLECTOR                              |

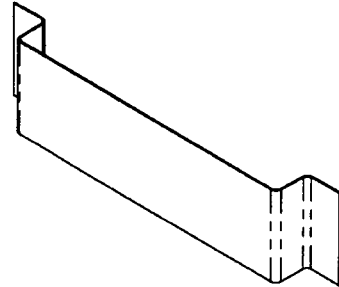
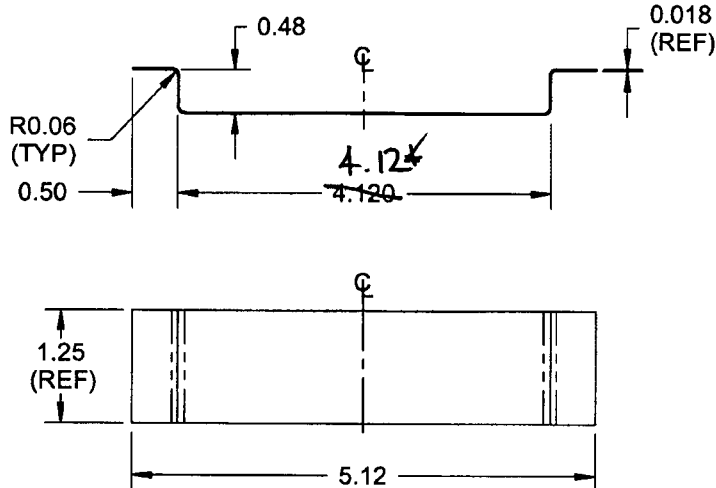
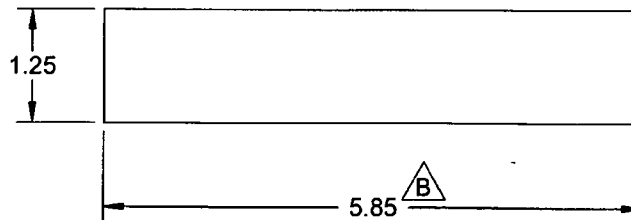
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**DART**

|                         |                      |  |                          |
|-------------------------|----------------------|--|--------------------------|
| DESIGN<br><i>B</i>      | DRAWN BY<br><i>B</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                          |
| CHECKED<br><i>H</i>     | APPROVED<br><i>H</i> | DRAWING NO.<br><b>D3467</b>                              | REV. B<br>SHEET 13 OF 15 |
| DATE<br><b>06.05.15</b> |                      | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:2             |

**RELEASED**  
*06-05-15***UNDER REVIEW***CA. 09.03.15**Dim & Manufacturing  
Change**09.01.14***D3467-15 DEFLECTOR BENDING DETAIL**

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WORK ORDER  
NO. *14609*

**D3467-15F DEFLECTOR FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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